

Work Order ID 57384

April 6, 2010 9:51:57 AM



Page 1

Item ID: D3574-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Floor Protector

Start Date: 4/06/10 Start Qty: 4.00



Cust Item ID:

Required Date: 4/09/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *PS*

Date: *10-4-06*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3574

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3574 ☐ Dwg Rev: *B* ☐ Prog Rev: *B* ☐ 2-
Deburr if necessary

IB 10-4-8

(9)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

IB 10-4-8

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Solorlos

(+4)

Work Order ID 57384

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Page 2

Item ID: D3574-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Floor Protector

Start Date: 4/06/10 Start Qty: 4.00



Cust Item ID:

Required Date: 4/09/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

0.00

Small Fab

Memo

Debur if necessary.

Small Fab

= 7 m. 10/04/09

4X

140

0.00



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

8/10/04/09

X4

150

0.00



Identify as per dwg & Stock Location:

0.00

Packaging

Memo

Packaging

PDP
57382

10/04/09 4

Work Order ID 57384

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Page 3

Item ID: D3574-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Floor Protector

Start Date: 4/06/10 Start Qty: 4.00



Cust Item ID:

Required Date: 4/09/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/12 *[Signature]*
ME
10-4-9

Picklist Print

April 6, 2010 9:51:57 AM

Page 1

Work Order ID: 57384

Parent Item: D3574-2

Parent Item Name: Cabin Floor Protector

Comments: IPP Rev :A New Issue 07-01-22 EC

Start Date: 4/06/10

Required Date: 4/09/10

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No				sf	3,040.000	134.4672			



GE PLASTICS LEXAN SHEET



B 10-4-8

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	3040	
111710	64	
112585	224	
114032	2752	

(4)

114032

DART AEROSPACE LTD		Work Order:	52384
Description: Cabin Floor Protector		Part Number:	D3574-2
Inspection Dwg: D3574	Rev: B	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.005	X			
7.37	+/-0.030	7.37	X			
10.75	+/-0.030	10.75	X			
11.00	+/-0.030	11.00	X			
15.25	+/-0.030	15.25	X			
25.87	+/-0.030	25.87	X			
39.75	+/-0.030	39.75	X			
44.75	+/-0.030	44.75	X			
53.51	+/-0.030	53.51	X			
63.50	+/-0.030	63.50	X			
65.25	+/-0.030	65.25	X			
10.75	+/-0.030	10.75	X			
11.00	+/-0.030	11.00	X			
14.75	+/-0.030	14.75	X			
25.50	+/-0.030	25.50	X			
25.75	+/-0.030	25.75	X			
26.00	+/-0.030	26.00	X			
32.87	+/-0.030	32.87	X			
38.81	+/-0.030	38.81	X			
45.00	+/-0.030	45.00	X			
48.25	+/-0.030	48.25	X			
58.38	+/-0.030	58.38	X			
61.25	+/-0.030	61.25	X			
64.13	+/-0.030	64.13	X			
64.63	+/-0.030	64.63	X			
66.50	+/-0.030	66.50	X			
7.50	+/-0.030	7.50	X			
9.50	+/-0.030	9.50	X			
10.38	+/-0.030	10.38	X			
10.88	+/-0.030	10.88	X			
14.50	+/-0.030	14.50	X			
16.56	+/-0.030	16.56	X			
18.75	+/-0.030	18.75	X			
24.13	+/-0.030	24.13	X			

MISSISSIPPI

DART AEROSPACE LTD		Work Order:	52384
Description: Cabin Floor Protector		Part Number:	D3574-2
Inspection Dwg: D3574	Rev: B	Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

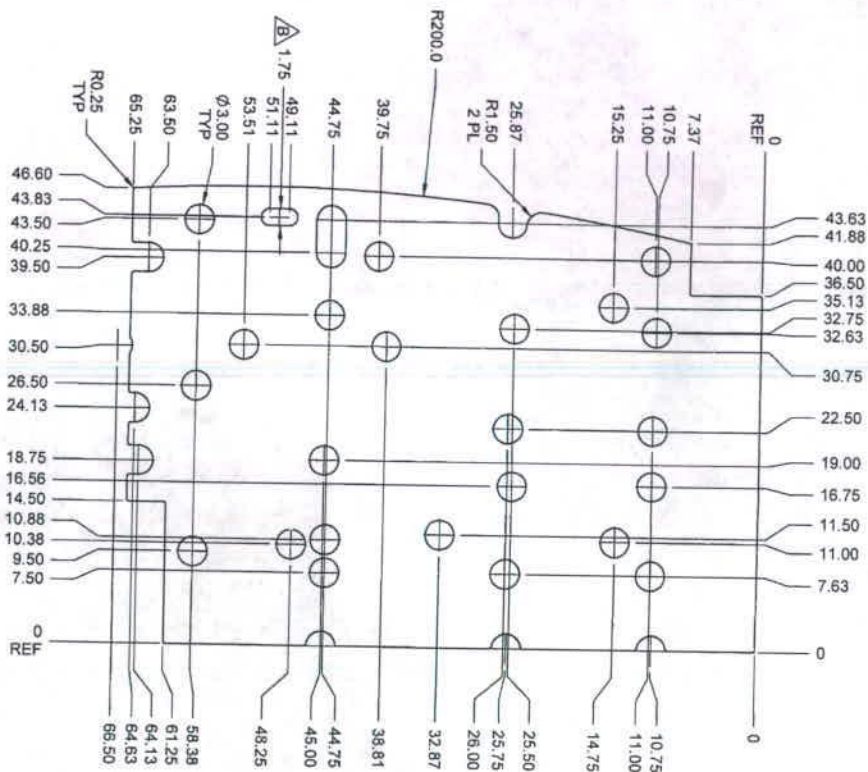
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.50	+/-0.030	26.50	X			
30.50	+/-0.030	30.50	X			
33.88	+/-0.030	33.88	X			
39.50	+/-0.030	39.50	X			
40.25	+/-0.030	40.25	X			
43.50	+/-0.030	43.50	X			
46.60	+/-0.030	46.60	X			
7.63	+/-0.030	7.63	X			
11.00	+/-0.030	11.00	X			
11.50	+/-0.030	11.50	X			
16.75	+/-0.030	16.75	X			
19.00	+/-0.030	19.00	X			
22.50	+/-0.030	22.50	X			
30.75	+/-0.030	30.75	X			
32.63	+/-0.030	32.63	X			
32.75	+/-0.030	32.75	X			
35.13	+/-0.030	35.13	X			
36.50	+/-0.030	36.50	X			
40.00	+/-0.030	40.00	X			
41.88	+/-0.030	41.88	X			
43.63	+/-0.030	43.63	X			
0.125	+/-0.010	0.130	X			

Measured by: HB	Audited by: S	Prototype Approval:	N/A
Date: 10-4-8	Date: 10/4/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	

- NOTES:
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MEXS.125-F60029-04)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART PIN "D3574-1" AND BAN USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
 - 7) WEIGHT: 14.30 lbs
 - 8) CHECK PER TEMPLATE DT8961

D3574-1 CABIN FLOOR PROTECTOR



0.125
REF

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57384
RM 10-4-06

RELEASED
09/17/10

REV.	DESCRIPTION	DATE
A	ADD CUT-OUT TO -11.5 FOR WEIGHT AND BALANCE DATA	09.03.25
B	PLATE ZN B7-1, B8-5, -2 NOW SHOWN ON SHEET 2	07.06.08
C	NEW ISSUE	
D		
E		
F		
G		
H		
I		
J		
K		
L		
M		
N		
O		
P		
Q		
R		
S		
T		
U		
V		
W		
X		
Y		
Z		

DATE 09.03.25

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DART AEROSPACE LTD.

1000 SHEPPARD AVENUE EAST, SUITE 100, SCARBOROUGH, ONTARIO, CANADA M1S 1T5

REV. B

SHEET 1 OF 6

SCALE

NTS

CABIN FLOOR PROTECTOR

D3574

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

BY

DATE

09.03.25

07.06.08

09.03.25

07.06.08

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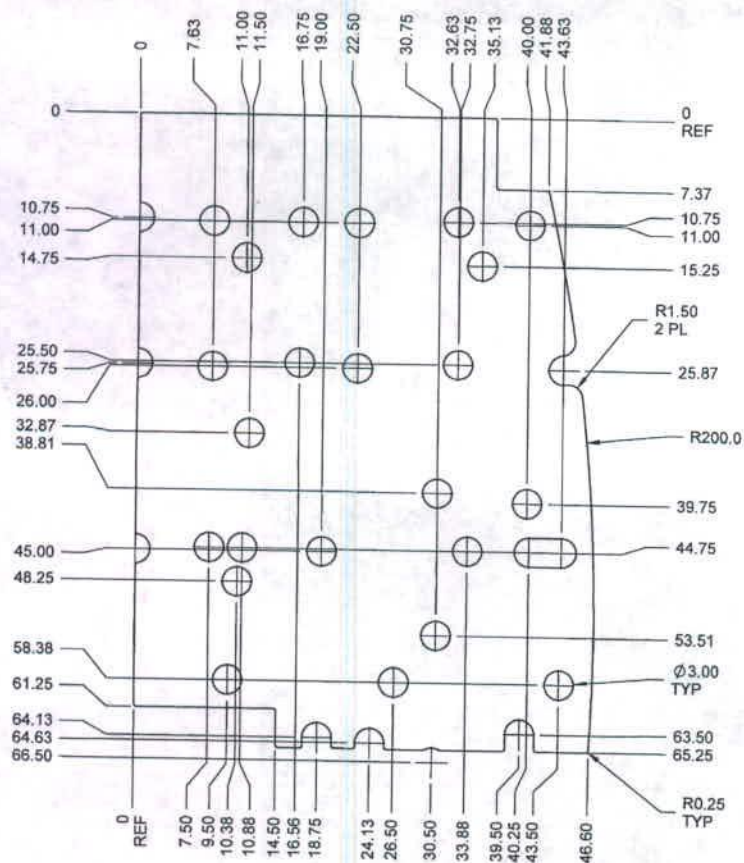
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09.03.25

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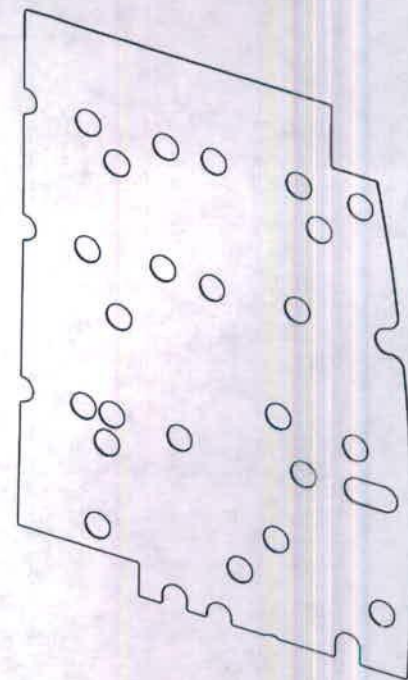


D3574-2 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-2" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

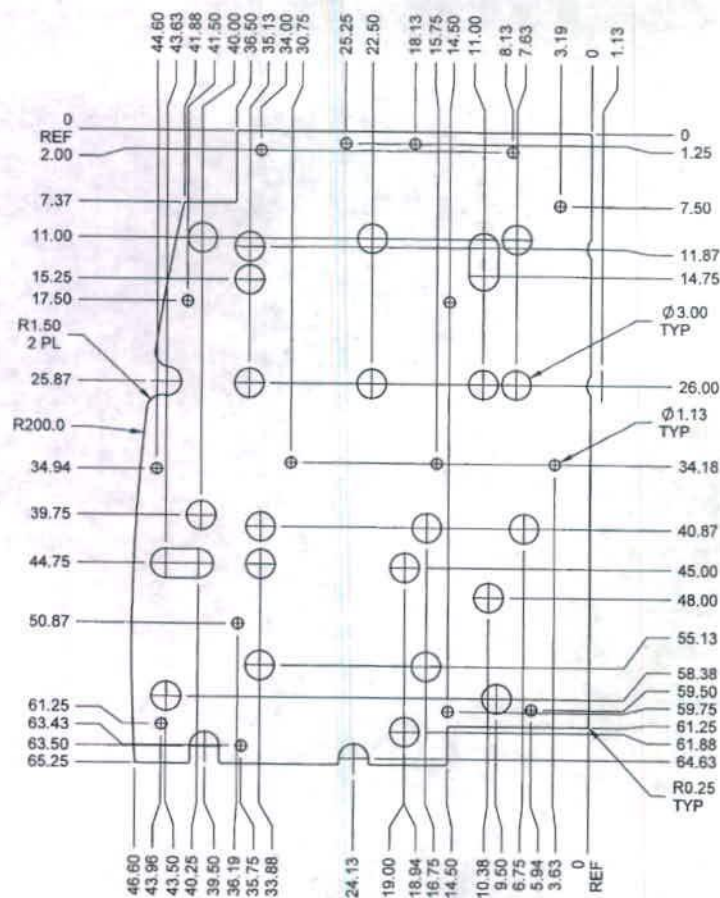
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REF



w/o 57384

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01/04/01 JMD

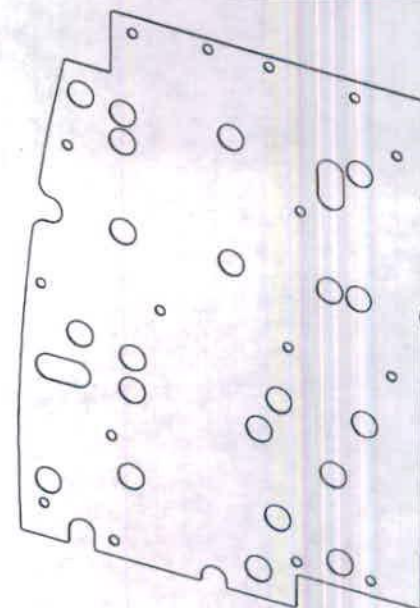
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MFG. APPR.			D3574	SHEET 2 OF 8
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D3574-3 CABIN FLOOR PROTECTOR

NOTES:

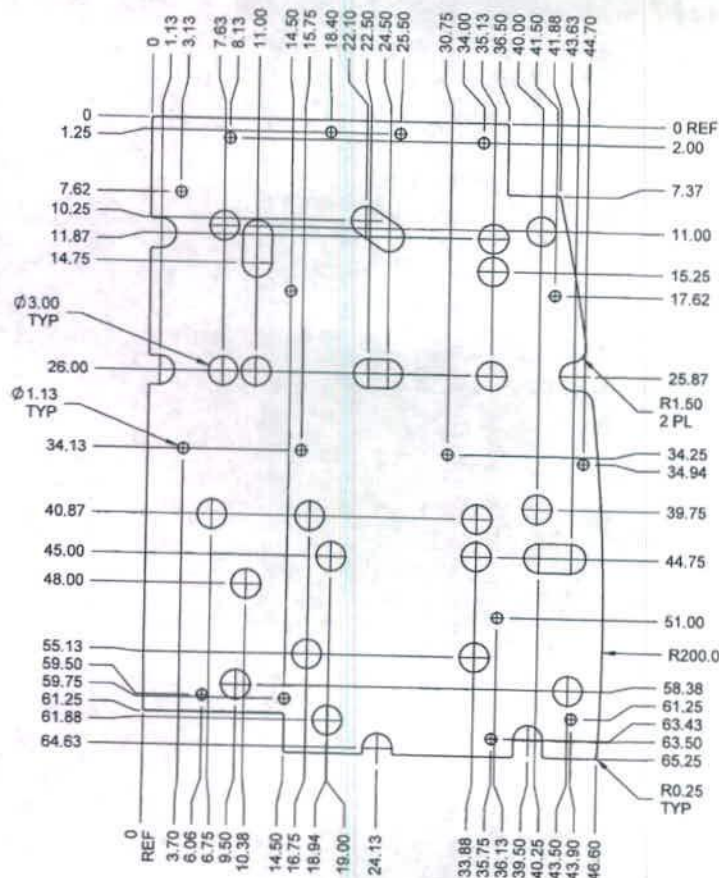
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-3" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.33 lbs
- 8) CHECK PER TEMPLATE DT8962



w/6 57384

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01/14/07

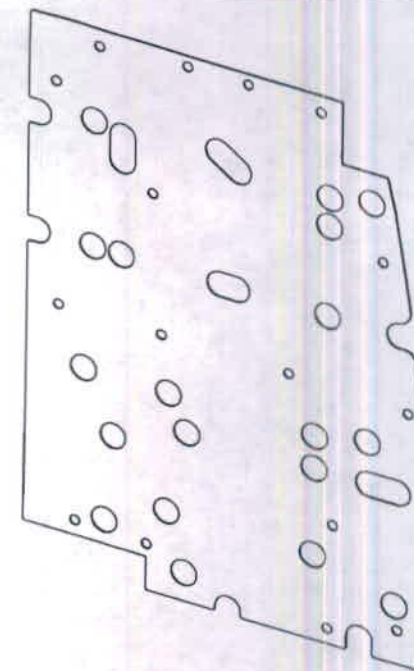
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D3574-4 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-4" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.18 lbs
- 8) CHECK PER TEMPLATE DT8963



w/057384

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8/13/07 JHP

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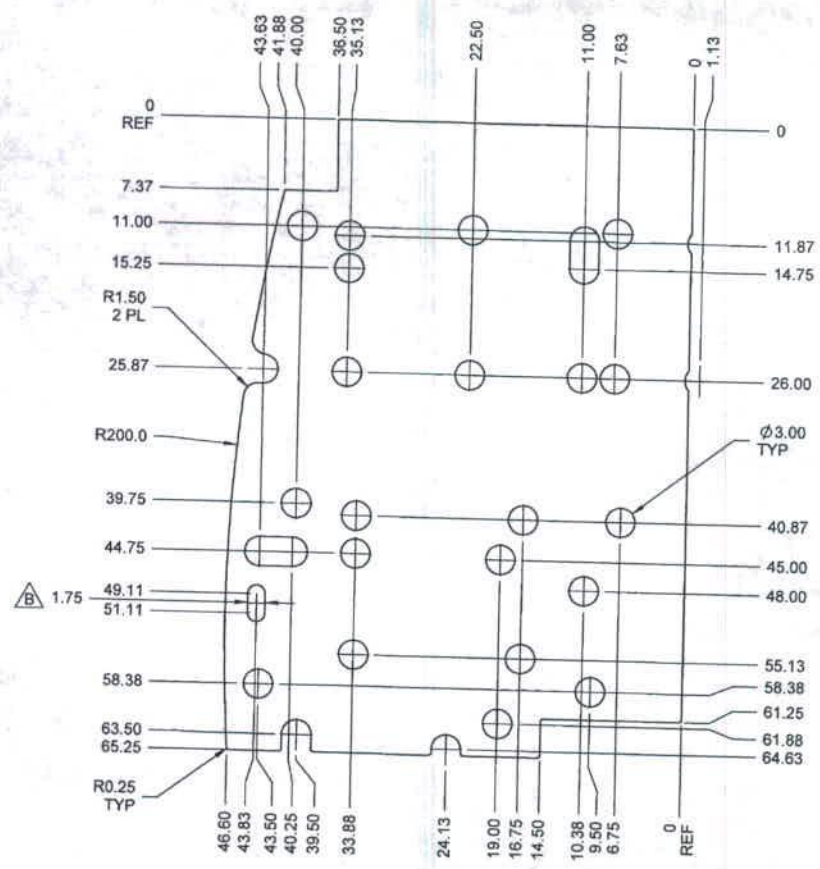
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D

C

B

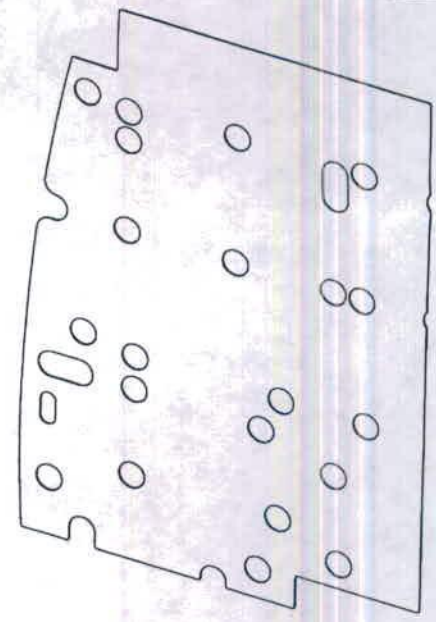
A



D3574-5 CABIN FLOOR PROTECTOR

- NOTES:**
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-5" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
 - 7) WEIGHT: 14.38 lbs
 - 8) CHECK PER TEMPLATE DT8964

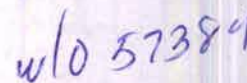
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- NOTES:**
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-6" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
 - 7) WEIGHT: 14.27 lbs
 - 8) CHECK PER TEMPLATE DT8965

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